Work Order I March 10, 2010 3:52										Page	
Revision ID:	rshoe		Accept					Setup	Start Stop		
Start Date: 10/0 Required Date: 17/0 Reference:	3/2010 Start Qty: 10.00 3/2010 Req'd Qty: 10.00	# 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		Cust Item I Customer:	D:						
	ocess Plan:	Date: <u>//2/-/-/-/</u>	Tooling: _ SPC (Y/N):		ite:			Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		keject Iumber	Insp. Stamp
Draw Nbr	Revision Nbr										
D3535	Rev B		- 7	- <b>3</b>							
Waterjet FLOW CNC Waterjet 304. 040	FLOW WATER JET  Memo  I-Cut as per Deburr if no	r Dwg D3535 — CDwg Rev:	0.00 0.00 BProg Rev:_	<u>B</u> t2-				<u>(0</u> ~	3-32	) 	
110	QC2- Inspect parts off n	nachine FAI/FAIR	0.00	. <b>₹</b>						(13	
QC Quality Control	Мето	1 / W ( / MD	0.00				æ	_ (O=	3-34	رر	

120

QC8- Inspect parts - second check

Quality Control

Memo

Dart Aerospace !
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w/o: 5	6839	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/30	# 170	Took Ofy +1 for al inspection template	2	10/3/30	*/		5/0/30

Part No: PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E	3	Varification A		Approval QC Inspector		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng			
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Work	Order	ID	56839





Page 2

Item ID:

D3535-25

Accept



Setup Start

Stop

Stop



**Revision ID:** 

Item Name:

Wearshoe

**Start Qty: 10.00** 10/03/2010

**Required Date:** 17/03/2010 Reg'd Otv: 10.00



**Cust Item ID:** 

**Customer:** 

Number

Reference:

Approvals:

Process Plan:

Date: \_\_\_\_\_ **Tooling:** 

Date:

Start Run

**Qty** 

Sequence ID/

Date: SPC (Y/N):

Draw

Draw Rev.

Date:

Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

Work Center ID 130

Brake NC

Brake NC

NC BRAKE

Memo

Memo

QC5- Inspect part completeness to step on W/O

Operation

Description

0.00

0.00

Set Up/

**Run Hours** 

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

140

150

QC

0.00

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

=) Il 10/04/07 X12 8

Powdercoat Powder Coating

Memo

OVEN TEMPERATURE:

START TIME: 3:45 DEINISH TIME:

Start Date:

March 10, 2010 3:52:02 PM

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W/O:			WORK ORDER CHANGES							
DATE	STEP	PR	OCEDURE CHAN	IGE	·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		PAR #:	Fault Categ	NCR: Yes No DQA: Date:						
		solution:								
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR	)			
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	. Section		Chief Eng	QC Inspector
									,	

March 10, 2010 3:52:02 PM

**Required Date:** 17/03/2010

Item ID:

D3535-25

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

**Start Date:** 

Wearshoe

10/03/2010

Start Qty: 10.00 Reg'd Oty: 10.00

**Cust Item ID: Customer:** 

Plan

Code

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

Date:

Draw

Rev.

Start Run

QC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Stop

Reject

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

0.00

10-4-8

Number

Draw

Qty

Accept

Qty

Reject

Number Stamp

Insp.

170

Packaging

Packaging

Identify as per dwg & Stock Location P-18

QC21- Final Inspection - Work Order Release

0.00 M 10/04/08

0.00

X12 Ø

180

0.00

Memo

0.00

10/04/129

4 1004.08

Quality Control

Dart	Aer	os	pace	Ltd
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W/O:	<u> </u>		W	ORK ORDER CHANG	FC	**		-v.		
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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					QA: N/C Closed: Date:					
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NCR	)			<b>3</b> 0	
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval	
	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector		

#### **Picklist Print**

March 10, 2010 3:52:06 PM

Work Order ID: 56839

Parent Item:

D3535-25

Parent Item Name:

Wearshoe

IPP Rev:A

IPP Rev:B

New Issue 07-02-15 JLM

As per Rev B 07-08-31 JLM

Verified By:EC

Start Date: 10/03/2010

**Required Date: 17/03/2010** 

**Start Qty: 10.00** 

Required Qty: 10.00

Component Item ID/ Item Name

304/316 .040 Sheet

M304S20GA

Comments:

Replacement Mfg/ Item ID

Purch Purchased

Primary Bin Location Item No

Last Location

Route Seq ID 100

Unit of Measure sf

Qty on Hand

Remaining Qty To Pick 164.6946 5.3684

Oty Issued ٦,

Date Issued

Status

Page 1

B10-3-30

Warehouse	Loc Oty	Loc Code		
<b>Location</b>				
Main Warehouse				13
MAT	164.6946053			راع
110076	0.40253684			_
112567	38.0765789			
112885	30.733		113885	
113062	86.9623			
113077	8.52018947			

Dart	<b>Aeros</b>	pace	Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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	Resolution: Disposition:				QA: N/C Closed: Date:						
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DATE	STEP	Description of NC	Corrective Action Section B			Verif	cation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		tion C	Chief Eng	QC Inspector		
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DART AEROSPACE LTD	Work Order:	54839
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X Fire	st Article		Prototype
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	Dimension	Accept	Reject	Method of Inspection	Comments
+/-0.010	1.886	8			<del>.</del>
+/-0.010	1.938	8			
+/-0.010		W			·
+/-0.010		12-			
+/-0.010		-			
+/-0.010					
+/-0.010					
+0.005/-0.001					
+/-0.010					
+/-0.030	6750				
+/-0.030					-
+/-0.010					
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Measured by:	IB	Audited by:	Prototype Approval:	N/A
Date:	10-3-36	Date: 10 (03/30	Date:	N/A

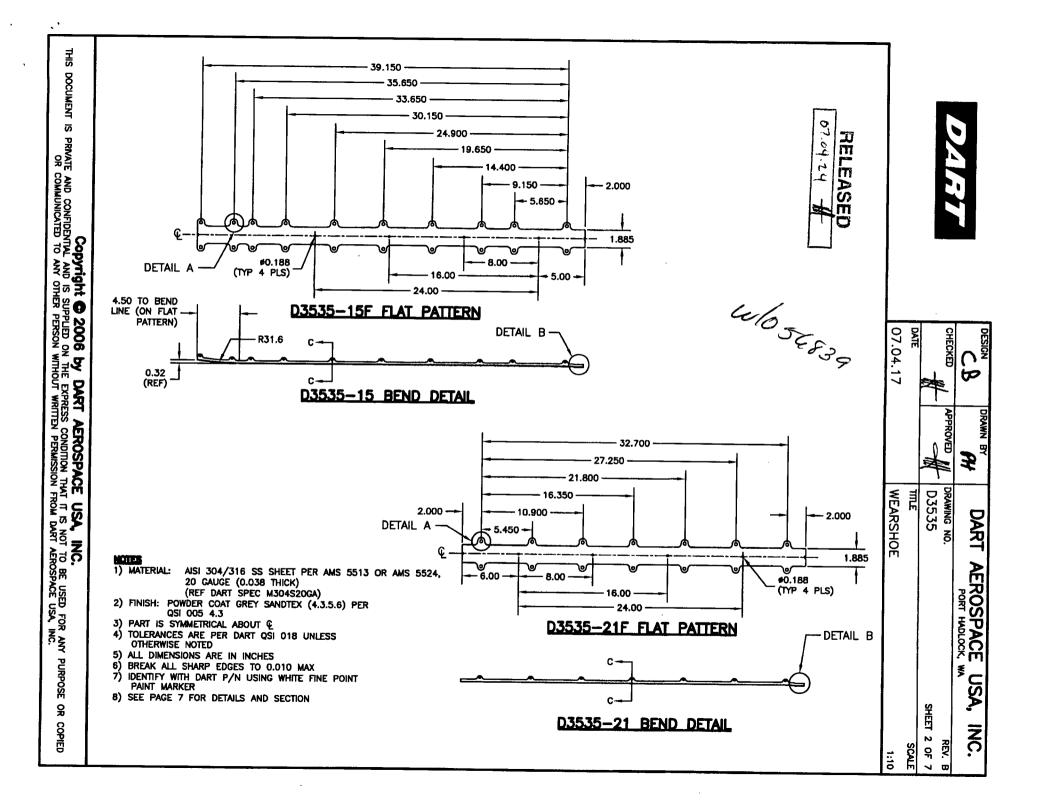
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD ./\	
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		Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & Se	ection C	Chief Eng	QC Inspector			

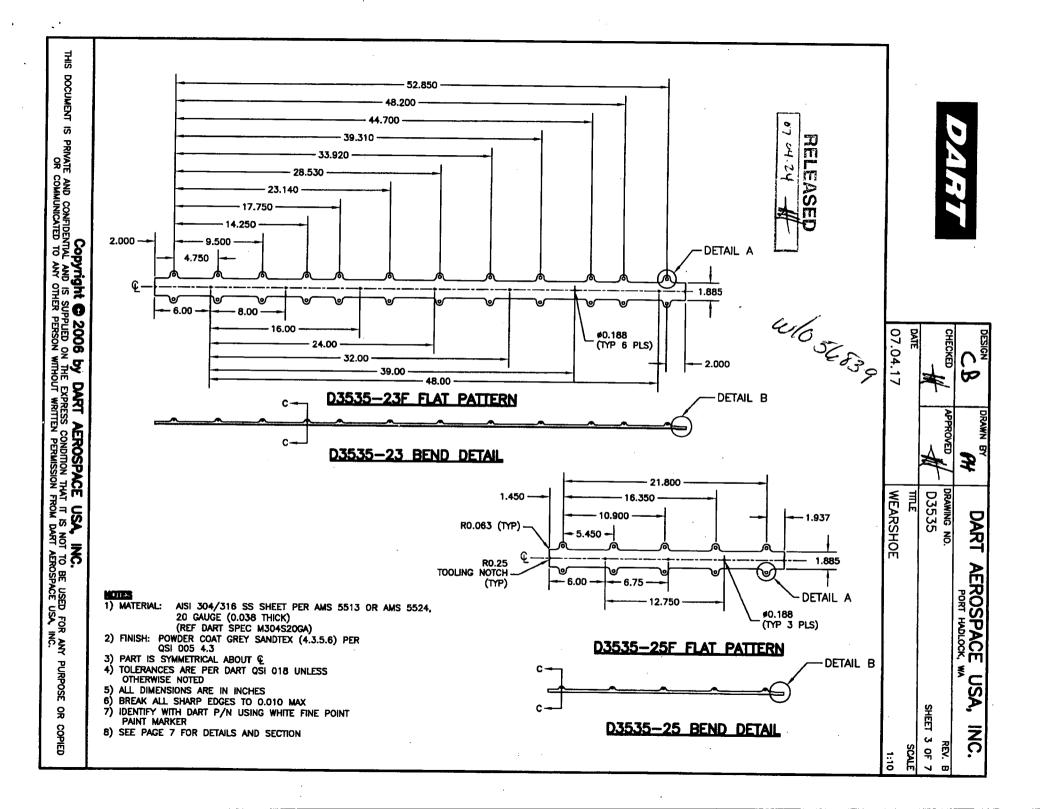
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		esolution:							
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DATE	STEP	Description of NC	Corrective Action Section B		Var		ation	Approval	Approval
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## **Dart Aerospace Ltd**

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CHECKED

DRAWING NO.

WEARSHOE

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DART

AEROSPACE

USA,

RC.

SHEET

4 of REV.

SCALE 1:10

DATE 07.04.17



D3535-31F FLAT PATTERN

- 22.500 -19.000 14.250

DETAIL A

**¢**0.188 (TYP 3 PLS)

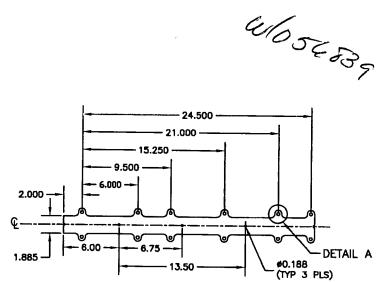
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2.000

1.885

D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



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COPIED

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK)

(REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER

QSI 005 4.3

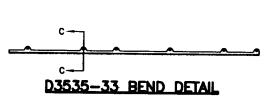
PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

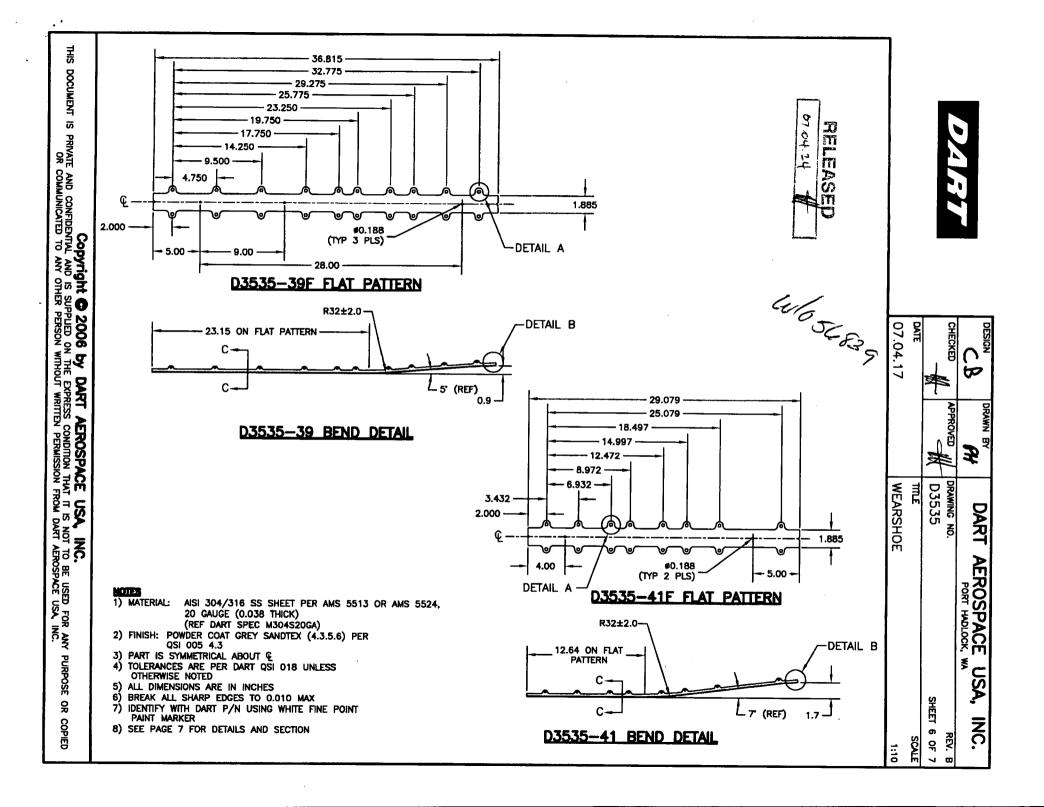
8) SEE PAGE 7 FOR DETAILS AND SECTION



#### **Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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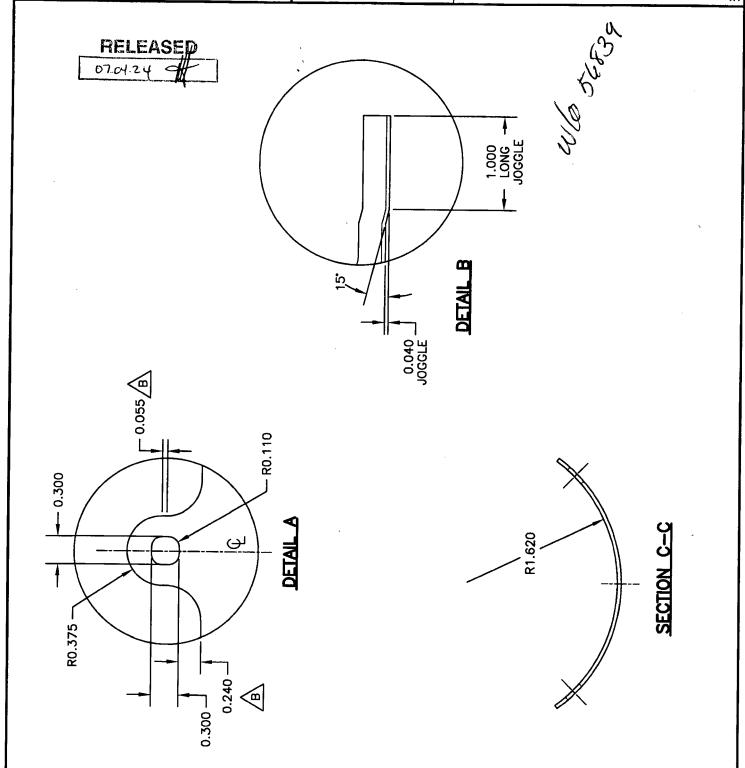


## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
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CHECKED	APPROVED _//	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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W/O:	-		V	ORK ORDER CHAN	IGES						
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